



WORK ORDER 2008-06

Date opened: 6 February 2008

Project: Attachment Provisions
Type: Eurocopter AS350/355 SeriesBatch Quantity: 2 Sets of 4 Clamp Assemblies (78620-01)
1 Pair Low Beams (78630-01)
1 Pair High Beams (78630-02)Approval: Pending 5/10/08-16
Drawing List: DCL786-3

Fabrication and Assembly Drawing(s)	Description
78620, Rev. 0	Clamp Ass'y
78630, Rev. 0	Low Beam
78631, Rev. 0	High Beam

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

List all non-conformities raised: _____

Inspector Signature:
Date:~~SEE WO 2008-05 FOR RELEASE TAGS~~

Drawing: 78620 Revision 0
Assembly: 78620-01 Clamp Ass'y

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 sets	78620-01	Clamp Assembly			
1	78620-02	Attachment Clamp	6061-T6 Aluminum, 3.5 x 1 bar	8014	
1	78620-03	Clamp	6061-T6 Aluminum, 3.5 x 1 bar	8014	
1	77620-04	Barrel Nut	304 Stainless Steel, 0.5 Dia Rod		
1	77620-05	Curved Washer	6061-T6 Aluminum, 0.5 Dia Rod		
3	3591-4CN375	1/4-28 Self Locking Helicoil		8016	
1	AN4-7A	Bolt			
1	AN4-20A	Bolt			
2	AN960-416	Washer			




Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 78620			<i>JC.</i>

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 78630 Revision 0
Assembly: 78630-01 Low Beam Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Pair	78630-01	Low Beam Assembly			
1	78630-02	Tube	304 Stainless Steel, 1x2x0.125 tube		
1	78630-03	Cap	321 Stainless Steel, 0.025 Sheet		
2	78630-04	Bushing	304 Stainless Steel, 0.375 x 0.058 Tube		
1	69830-07	Block	304 Stainless Steel, 0.25 Sqr. Rod		
1	69830-11	Guide	304 Stainless Steel, 0.75 x 0.065 Tube		
1	69830-21	Stop	6061-T6 Aluminum, 0.625 Rod		
1	69830-22	Knob	6061-T6 Aluminum, 0.75 Rod		
1	69830-23	Spring			
1	#10-32	C'Sunk Screw	Stainless		
1	MS21044C3	Nut			

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 78630			
Final Inspection	Drawing 78630			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 78631 Revision 0
 Assembly: 78631-01 High Beam Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Pair	78631-01	High Beam Assembly			
1	78631-02	Tube	304 Stainless Steel, 1x2x0.125 tube		
1	78630-03	Cap	321 Stainless Steel, 0.025 Sheet		
2	78630-04	Bushing	304 Stainless Steel, 0.375 x 0.058 Tube		
1	69830-07	Block	304 Stainless Steel, 0.25 Sqr. Rod		
1	69830-11	Guide	304 Stainless Steel, 0.75 x 0.065 Tube		
1	69830-21	Stop	6061-T6 Aluminum, 0.625 Rod		
1	69830-22	Knob	6061-T6 Aluminum, 0.75 Rod		
1	69830-23	Spring			
1	#10-32	C'Sunk Screw	Stainless		
1	MS21044C3	Nut			
	7029				

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		JP
Powder Coat	Drawing 78631			gc
Final Inspection	Drawing 78631			gc.

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

LAKESHORE
AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Clamp Assembly Part #: 78620-01
Approval #: SH08-16 Serial #: --
WO #: 2008-06 Quantity: 4
Eligibility: Eurocopter AS350/355 Series Work Status: Manufactured
Remarks: Including mounting hardware

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

April 11/08
Date

Jff Clark
Inspector's Signature

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Low Beam Assembly Part #: 78630-01
Approval #: SH08-16 Serial #: --
WO #: 2008-06 Quantity: 2
Eligibility: Eurocopter AS350/355 Series Work Status: Manufactured
Remarks: _____

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

April 11/08
Date

Jff Clark
Inspector's Signature

AIRSPAN

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Clamp Assembly Part #: 78620-01
Approval #: SH08-16 Serial #: --
WO #: 2008-06 Quantity: 4
Eligibility: Eurocopter AS350/355 Series Work Status: Manufactured
Remarks: Including mounting hardware

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

May 20/08
Date

Jeff Clarke
Inspector's Signature

AIRSPAN

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

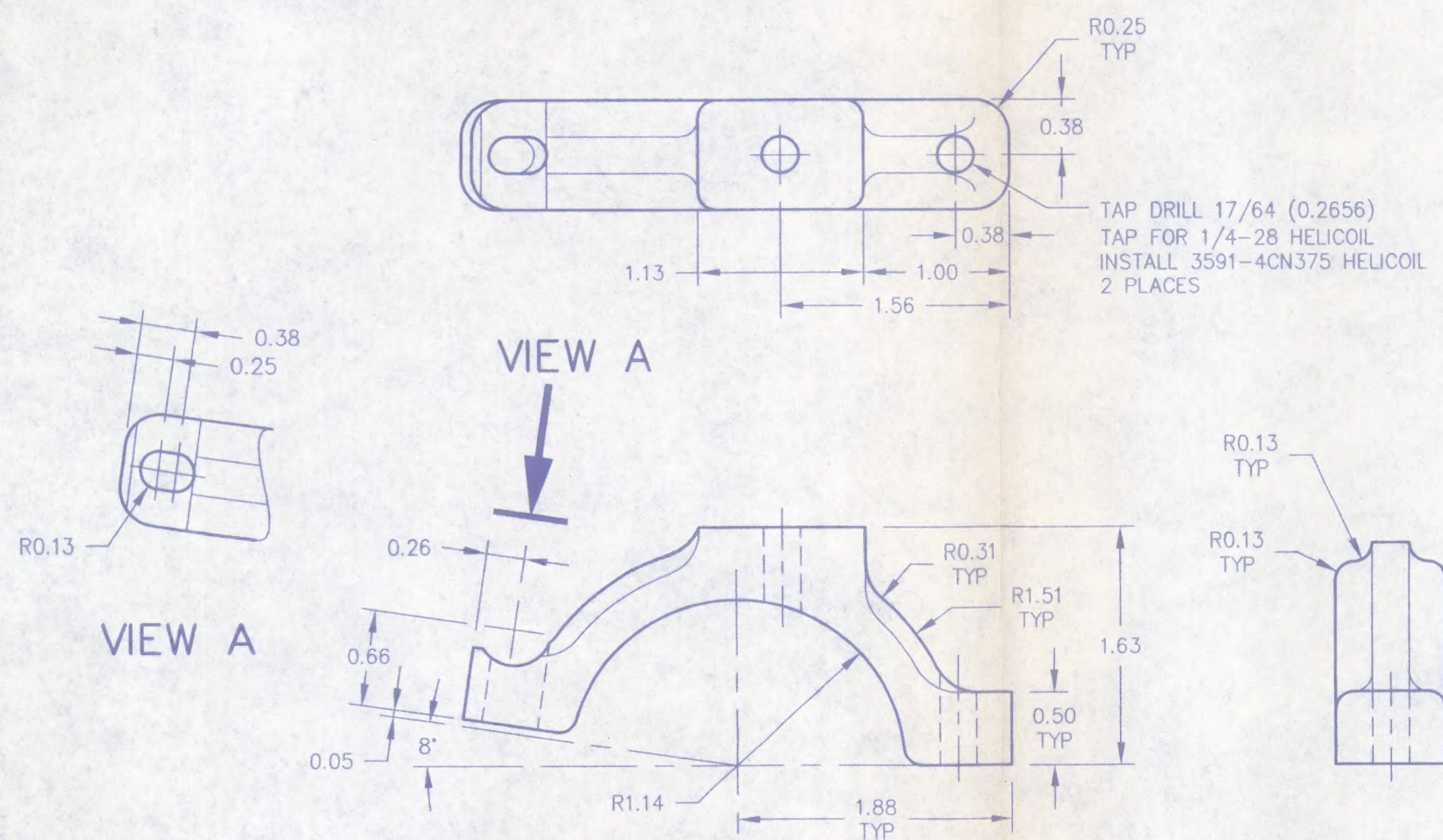
Product: High Beam Assembly Part #: 78631-01
Approval #: SH08-16 Serial #: --
WO #: 2008-06 Quantity: 2
Eligibility: Eurocopter AS350/355 Series Work Status: Manufactured
Remarks: _____

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

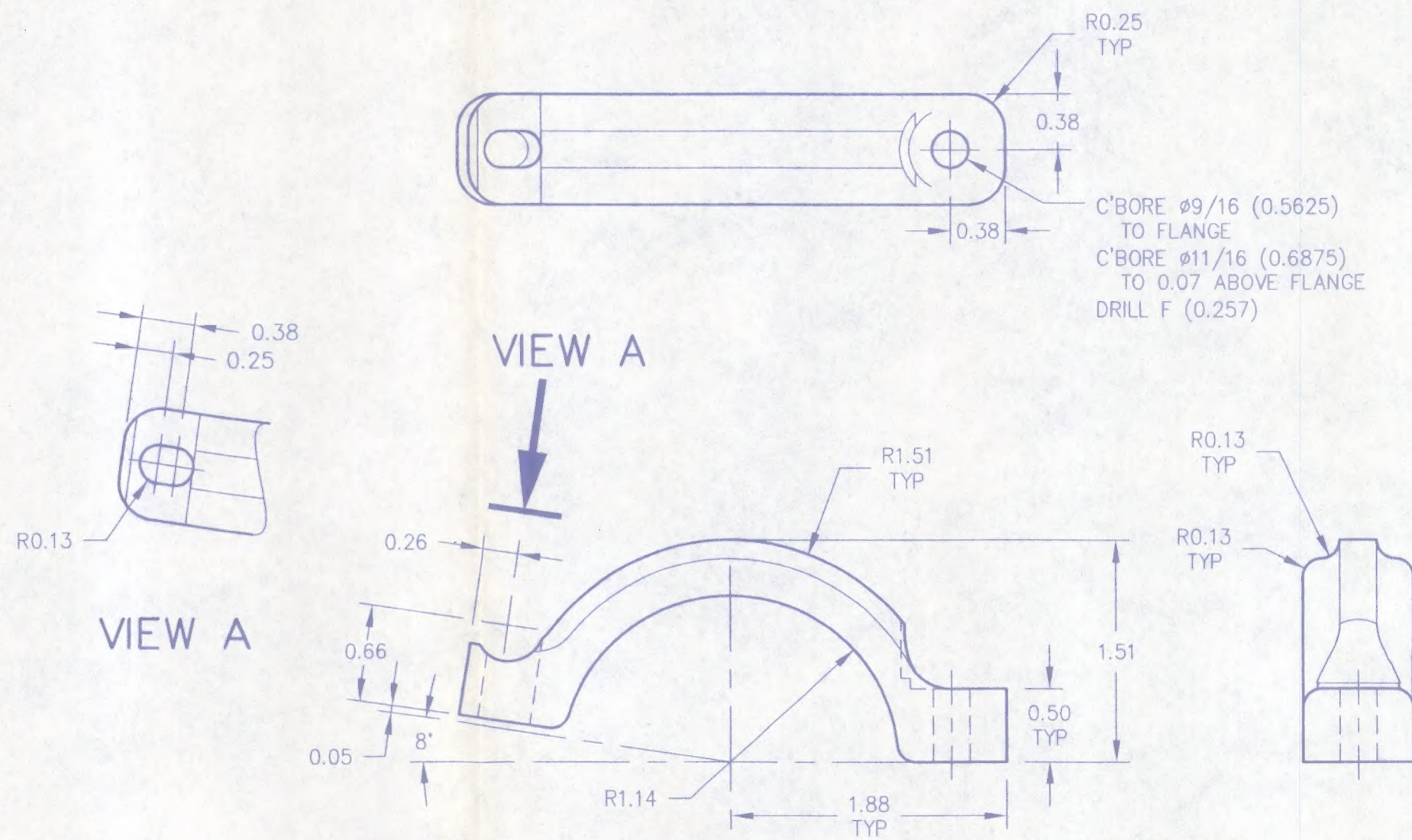
May 20/08
Date

Jeff Clarke
Inspector's Signature

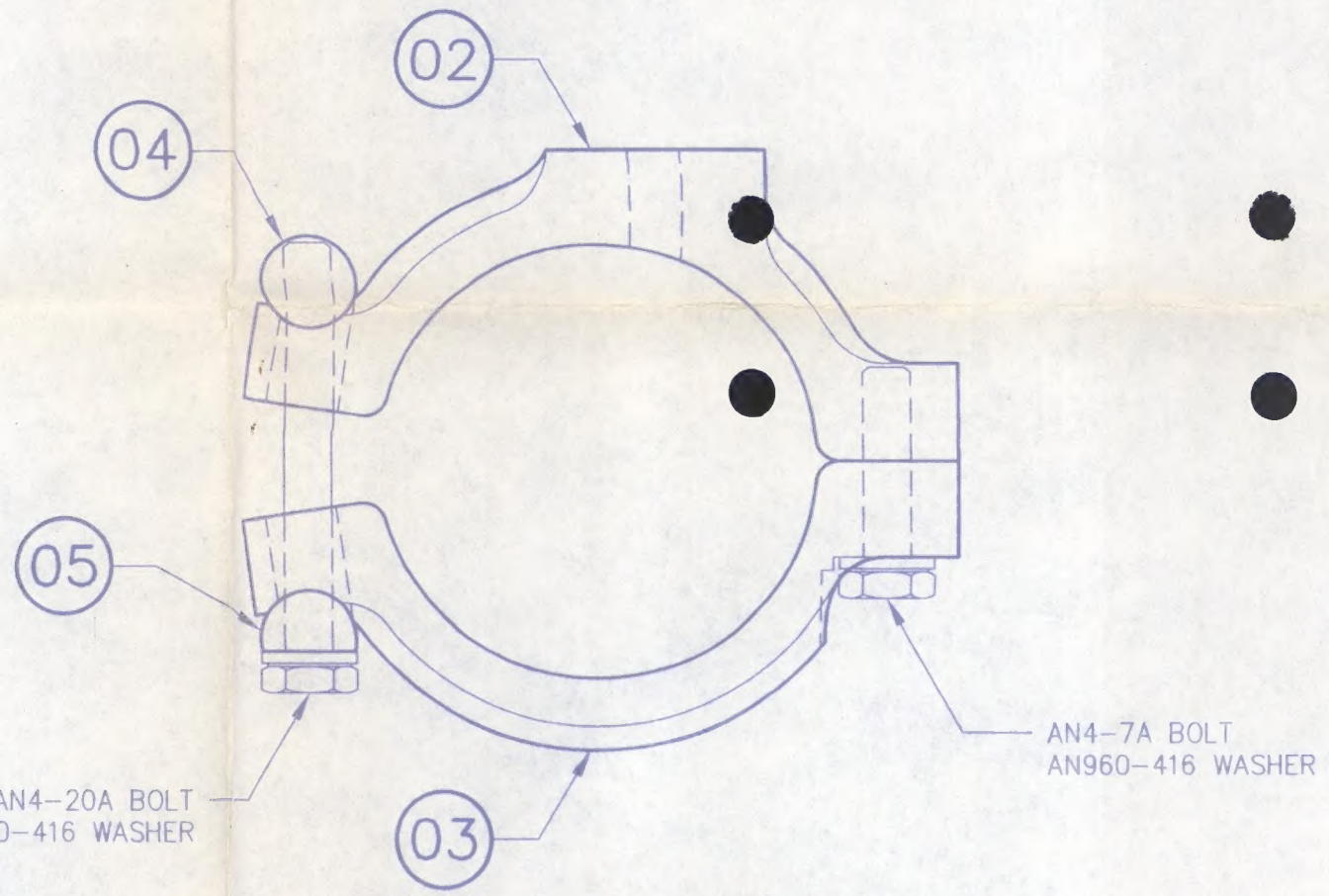
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0	INITIAL ISSUE		



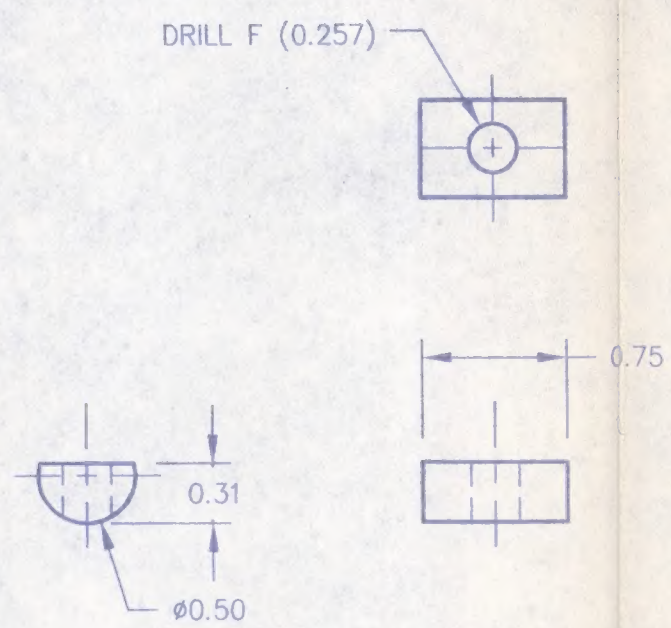
02 ATTACHMENT CLAMP
SEE NOTE 2



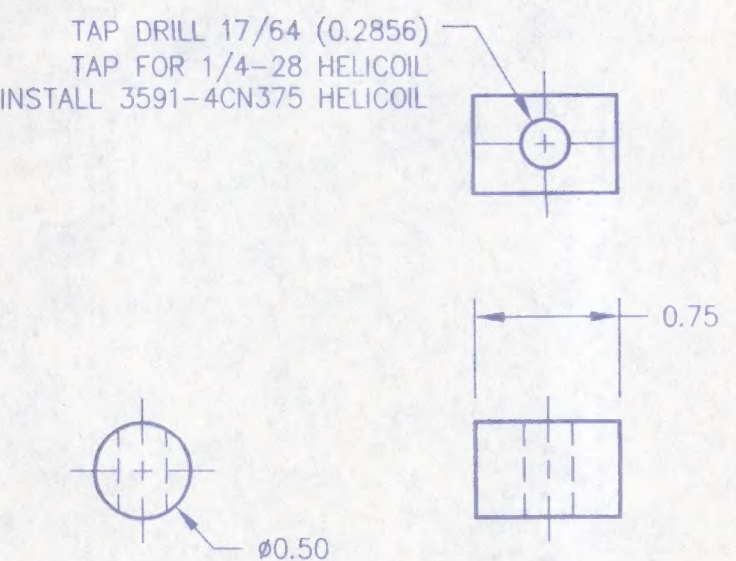
03 CLAMP
SEE NOTE 2



01 CLAMP ASSEMBLY



05 CURVED WASHER



04 BARREL NUT

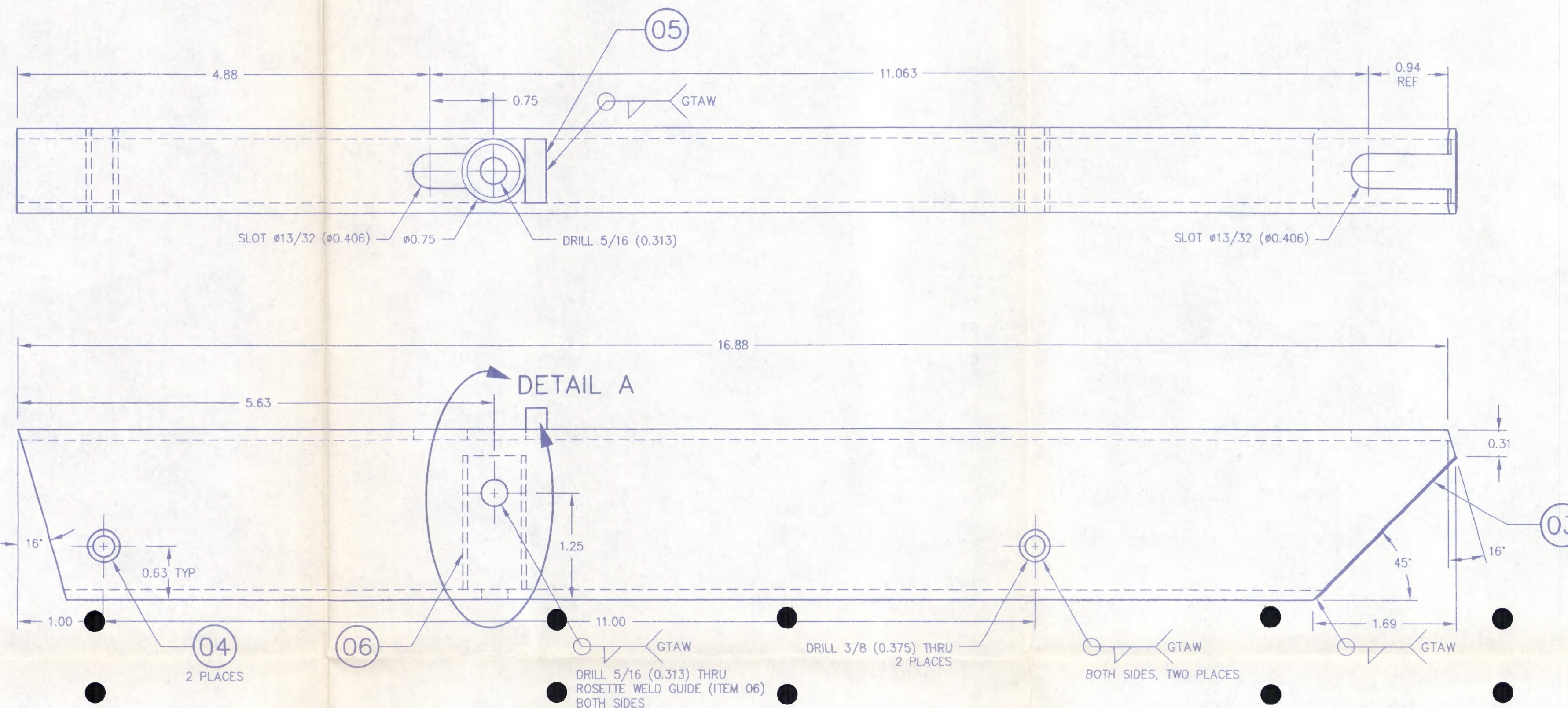
NOTES

- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- PARTS ARE CNC MACHINED AS A SET (ITEM 2/ITEM 3) FROM ONE PIECE OF MATERIAL.
- ALL ALUMINUM PARTS TO BE THOROUGHLY DEGREASED, ALODINED, PRIMED AND PAINTED PRIOR TO ASSEMBLY.

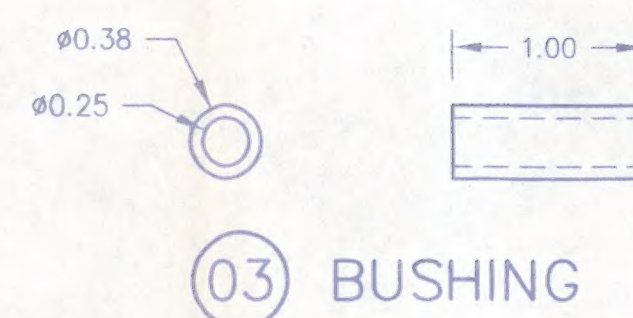
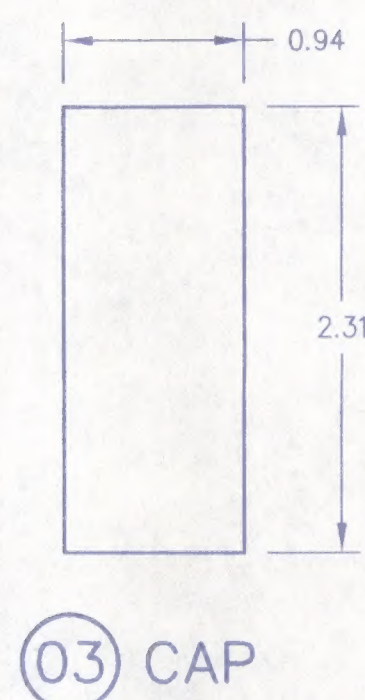
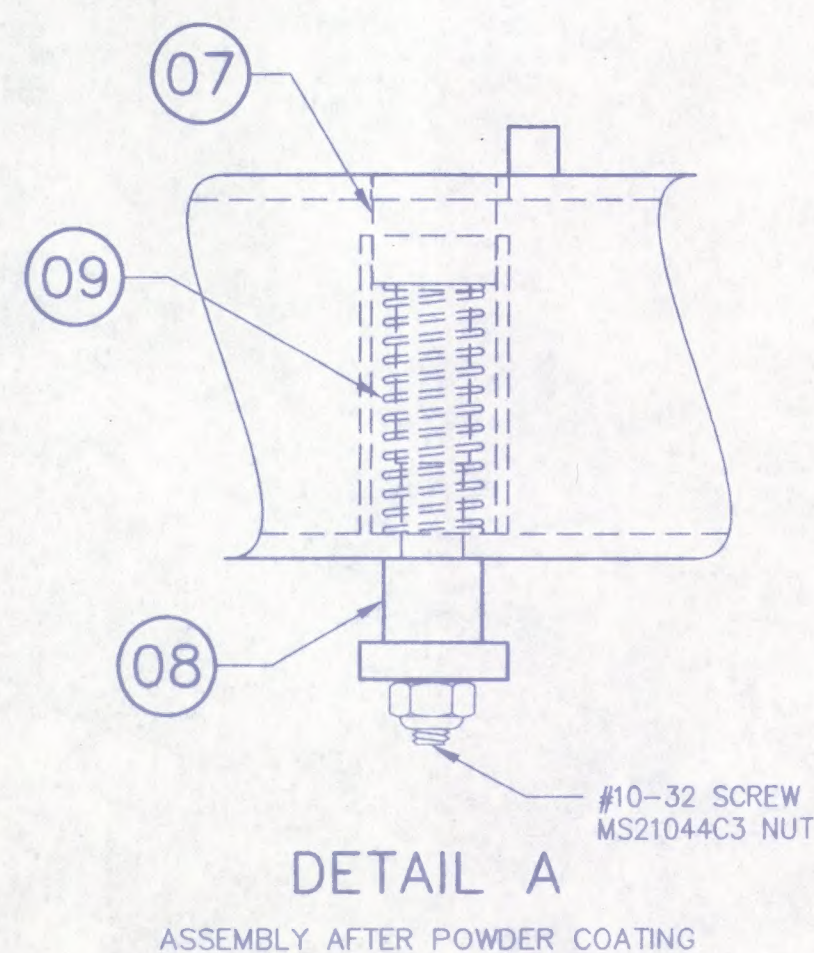
QTY	QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	2		AN960-416		WASHER			
	1		AN4-20A		BOLT			
	1		AN4-7A		BOLT			
	1		3591-4CN375		1/4-28 SELF LOCK HELICOIL			
	1		77620-05	05	CURVED WASHER	6061-T6 ALUMINUM	QQ-A-200/8	ø0.5 ROD
	1		77620-04	04	BARREL NUT	304 STAINLESS STEEL	MIL-S-5059	ø0.5 ROD
	1		77620-03	03	CLAMP	6061-T6 ALUMINUM	QQ-A-200/8	3.5 X 1.0 BAR
	1		77620-02	02	ATTACHMENT CLAMP	6061-T6 ALUMINUM	QQ-A-200/8	3.5 X 1.0 BAR
			77620-01	01	CLAMP ASSEMBLY			

		APPROVALS		DATE		AERO DESIGN LTD.					
DRAWN:		JEFF CLARKE		29 NOV 2007		CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M					
CHECKED:		E. BURGON				2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7					
						tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca					
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		EUROCOPTER AS350 & AS355 SERIES EXTERNAL ATTACHMENT PROVISIONS CLAMPS FABRICATION							
		DECIMALS		ANGLES		SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.	
		X.XXX ±0.010		±1/2°		SHEET 1 OF 1		A1	78620	0	
		X.XX ±0.03									
		X.X ±0.1									

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



01 LOW BEAM ASSEMBLY



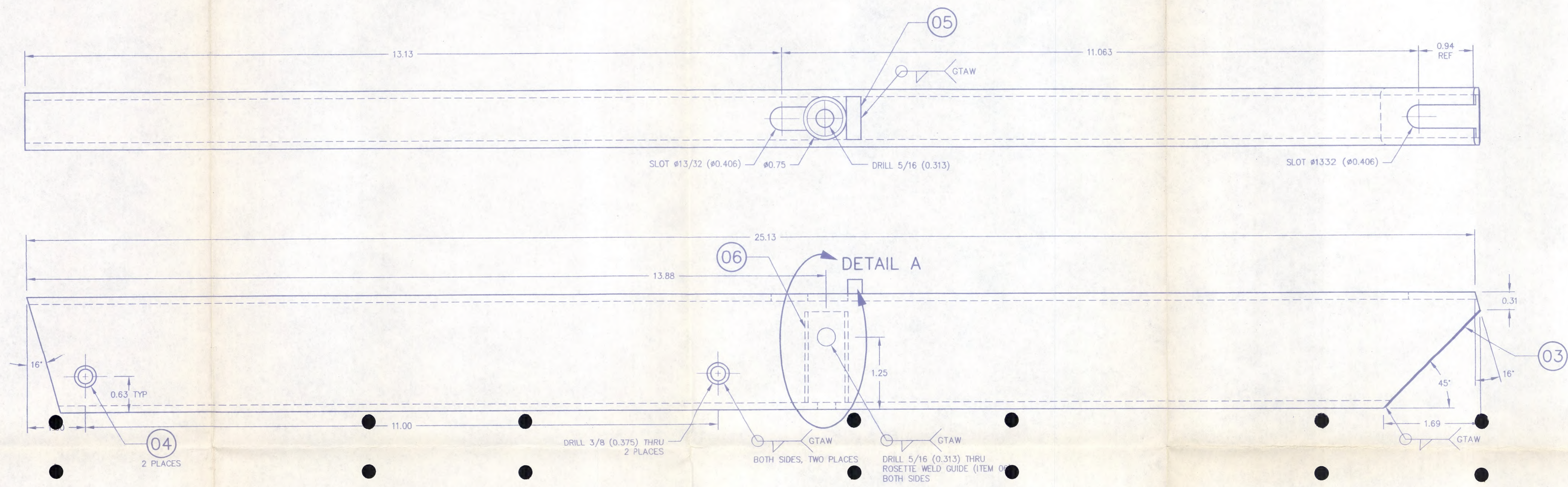
NOTES

- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
- ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY.

1	MS21044C3	NUT			
1	#10-32	C/SUNK SCREW	STAINLESS STEEL	COMMERCIAL	
1	69830-23	09 SPRING		COMMERCIAL	15mm X 70mm SPRING
1	69830-22	08 KNOB	6061-T6 ALUMINUM	QQ-A-200/8	#0.75 ROD
1	69830-21	07 STOP	6061-T6 ALUMINUM	QQ-A-200/8	#0.625 ROD
1	69830-11	06 GUIDE	304 STAINLESS STEEL	ASTM A269	#0.75 X 0.065 RND. TUBE
1	69830-07	05 BLOCK	304 STAINLESS STEEL	ASTM A479	0.25 SQR ROD
2	77630-04	04 BUSHING	304 STAINLESS STEEL	ASTM A269	#0.375 X 0.058 RND. TUBE
1	77630-03	03 CAP	321 STAINLESS STEEL	AMS 5510	0.025 SHEET
1	77630-02	02 TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	77630-01	01 LOW BEAM ASS'Y			
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC STOCK SIZE

LIST OF MATERIALS			
AERO DESIGN LTD.			
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca			
EUROCOPTER AS350 SERIES QUICK RELEASE CARGO BASKET LOW BEAM FABRICATION			
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	77630	0

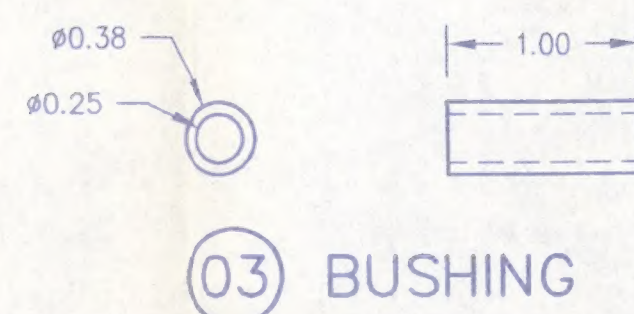
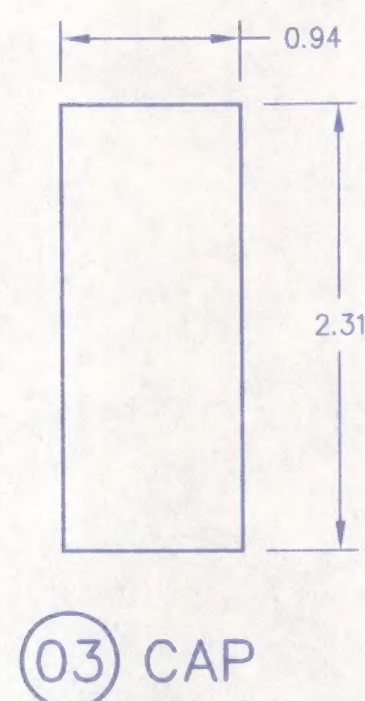
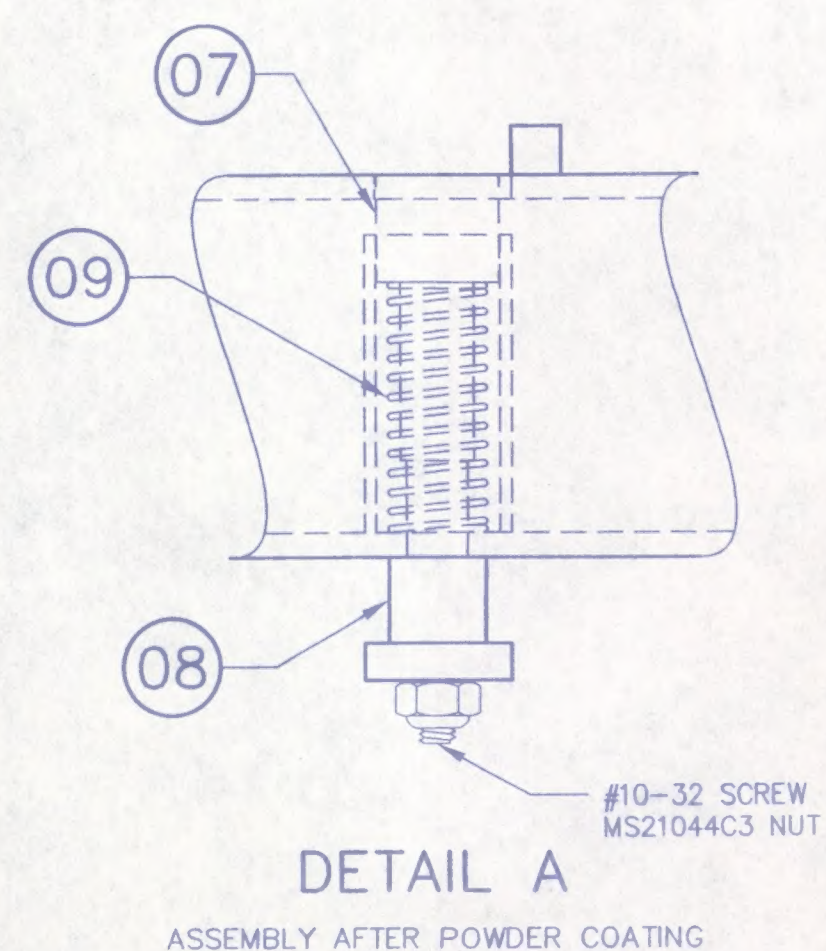
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



02 HIGH BEAM ASSEMBLY

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY.



1	MS21044C3	NUT				
1	#10-32	C/SUNK SCREW	STAINLESS STEEL	COMMERCIAL		
1	69830-23	09 SPRING		COMMERCIAL	15mm X 70mm SPRING	
1	69830-22	08 KNOB	6061-T6 ALUMINUM	QQ-A-200/8	Ø0.75 ROD	
1	69830-21	07 STOP	6061-T6 ALUMINUM	QQ-A-200/8	Ø0.625 ROD	
1	69830-11	06 GUIDE	304 STAINLESS STEEL	ASTM A269	Ø0.75 X 0.065 RND. TUBE	
1	69830-07	05 BLOCK	304 STAINLESS STEEL	ASTM A479	0.25 SQR ROD	
2	77630-04	04 BUSHING	304 STAINLESS STEEL	ASTM A269	Ø0.375 X 0.058 RND. TUBE	
1	77630-03	03 CAP	321 STAINLESS STEEL	AMS 5510	0.025 SHEET	
1	77631-02	02 TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE	
	77631-01	01 HIGH BEAM ASS'Y				
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

APPROVALS		DATE	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca			
DRAWN:	JEFF CLARKE	6 DEC 2007				
CHECKED:	E. BURGON					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			EUROCOPTER AS350 SERIES QUICK RELEASE CARGO BASKET HIGH BEAM FABRICATION			
DECIMALS	ANGLES		SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
X.XXX	±0.010 ±1/2"					
X.XX	±0.03					
X.X	±0.1		A1	77631	0	
SHEET 1 OF 1						

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M
2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7
tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca

**EUROCOPTER AS350 SERIES
QUICK RELEASE CARGO BASKET
HIGH BEAM FABRICATION**

SCALE 1 : 1 DWG. SIZE DWG. NO. REV.
SHEET 1 OF 1 A1 77631 0